

Re-Print



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4004-041

Job Sheet 204680



POSITIVE RECALL

Part No: D4004-041

Job Qty: 2 pcs

Part Name: Side Restraint Angle

EFFECTIVE 20-01-08 AUTH PD



RELEASED PD DATE 20-01-10

Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/16/19

Job Tracking No:

Due Date: 1/15/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B SHEETS 1,3,4 IPP rev A 09.12.15 new issue Prelim EC verified by:DD IPP Rev:B 10.05.17 as per ECN10-562 DD verf: IPP Rev:C 12.03.07 as per dwg rev.b DD verf: EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	2 pcs		1/15/20	0.17	0.37	Waterjet - Flow		20/01/09
110	QC 2	2 pcs		1/15/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		20/01/09
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

Plex 1/7/20 2:28 PM Dart.Renwick.Jennifer

1/7/2020

[Dart Hawkesbury] Job Sheet - Renwick, Jennifer

120 QC 8	2 pcs	1/15/20	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	JAN 09 2020
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
130 Small Fab - Brake NC - B4B	2 pcs	1/15/20	0.25 0.20	Small Fab - Brake - 1 - B4B	
				Small Fab - Brake - 2 - B4B	
				Small Fab - Brake - 3 - B4B	JAN 09 2020
140 QC 5	2 pcs	1/15/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	JAN 09 2020
				QC 5 - 61	
				QC 5 - 81	
150 Handfinish - 1-1 Chemical-B4B	2 pcs	1/15/20	0.00 0.18	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	JAN 09 2020

Plex 1/7/20 2:28 PM Dart.Renwick.Jennifer

					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
155	QC 7	2	1/15/20	0.00 0.00	QC 7 - 10	
		pcs			QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
					QC 7 - 76	
					QC 7 - 79	
160	Powdercoat - 9 Gloss Grey- B4B	2	1/15/20	0.00 0.12	Powdercoat - 1 - B4B	
		pcs			Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
170	QC 3	2	1/15/20	0.00 0.00	QC 3 - 10	
		pcs			QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	

Plex 1/7/20 2:28 PM Dart.Renwick.Jennifer

1/7/2020

[Dart Hawkesbury] Job Sheet - Renwick, Jennifer

				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	DAS 58 9-89 JAN 10 2020
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	DAS 58 9-89 JAN 10 2020
180 Small Fab - 2 - B4B	2 pcs	1/15/20	0.00 0.69	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
				Small Fab - 9 - B4B	
190 QC 5	2 pcs	1/15/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	DAS 40 9-89 JAN 10 2020
				QC 5 - 61	
				QC 5 - 81	
200 Packaging 3-1 - Stock - B4B	2 pcs	1/15/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	

Plex 1/7/20 2:28 PM Dart.Renwick.Jennifer

POSITIVE
RECALL

AD

20-01-10

				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	68-6
				Packaging 3 - 26 - B4B	87
				Packaging 3 - 27 - B4B	DAS
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
210 QC 21 - SA	2	1/15/20	0.00 0.00	QC 21 - SA - 21	DAS
	pcs			QC 21 - SA - 70	21
				QC 21 - SA - 53	8-08
Part Op 110 - QC2- Inspect parts off machine FAI/FAIB) Descriptions: 120 - (QC8- Inspect parts - second check) 130 - (Bend/Assemble as per dwg) 140 - (QC5- Inspect part completeness to step on W/O) 150 - (Chemical Conversion Coat per QSI005 4.1) 155 - (QC7-Inspect Chemical Conversion Coat) 160 - (Gloss Grey (4.3.5.15) per QSI 005 4.3) 170 - (QC3- Inspect Part Finish) 190 - (QC5- Inspect part completeness to step on W/O) 200 - (Identify as per dwg & Stock Location: _____) 210 - (QC21- Final Inspection - Work Order Release)					JAN 10 2020
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M2024T3S.063	2024-T3 .063 Sheet	.4400 sf (.22 ea)	100-Waterjet - Flow - 1	5180490	
D4004-3	Strut Lock Bracket	2 pcs (1 ea)	180-Small Fab - 2 - B4B	5194420	
D4004-7	Hose Clip	2 pcs (1 ea)	180-Small Fab - 2 - B4B	5234381	
MS20426AD4-4	Rivet	2 Ea (1 ea)	180-Small Fab - 2 - B4B	5243881	
MS20426AD4-5	Rivet	4 Ea (2 ea)	180-Small Fab - 2 - B4B	526234	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Waterjet - Flow - 1	M2024T3S.063	0	92	0	
180-Small Fab - 2 - B4B	D4004-3	2	2	0	
	D4004-7	2	10	0	
	MS20426AD4-4	2	637	0	
	MS20426AD4-5	4	449	0	
Part Specifications					
Specifications could not be found.					

DART AEROSPACE LTD		Work Order: 204680
Description: Side Restraint		Part Number: D4004-1
Inspection Dwg: D4004 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	Ø.101	1		Vis-02	
Ø0.129	+0.005/-0.001	Ø.130	1		Top	
3.65	+/-0.030	3.65	1			
0.223	+/-0.010	.223	1			
10.63	+/-0.030	10.63	1			
2.99	+/-0.030	2.99	1			
5.79	+/-0.030	5.79	1			
0.87	+/-0.030	.87	1			
2.40	+/-0.030	2.40	1			
1.38	+/-0.030	1.38	1			
0.50	+/-0.030	.50	1			
0.79	+/-0.030	.79	1			
0.38	+/-0.030	.38	1			
0.98	+/-0.030	.98	1			
1.18	+/-0.030	1.18	1			
1.56	+/-0.030	1.56	1			
0.063	+/-0.010	.062	1			

Measured by: <i>de</i>
Date: 20/01/09

Audited by: <i>DAS 40 9-80</i>
Date: JAN 09 2020

Preliminary Approval:
Date:

Rev	Date	Change	Revised by	Approved
A	10.08.03	New Issue P/O D4004-041	KJ	
B	13.02.27	Dwg Rev updated	KJ	